



| DASH NO. | PIN NOM. DIA. | THREAD         | A DIA.       | A <sub>1</sub> DIA. (REF.) | B DIA.       | L            | L <sub>1</sub> (REF.) | L <sub>2</sub> (REF.) | L <sub>3</sub> (REF.) | P (REF.) | W HEX.       | X (REF.) | X <sub>1</sub> (REF.) | UTS LBS. MIN. | TORQUE-OFF IN.-LBS. |
|----------|---------------|----------------|--------------|----------------------------|--------------|--------------|-----------------------|-----------------------|-----------------------|----------|--------------|----------|-----------------------|---------------|---------------------|
| 5        | 5/32          | 8-32UNJC-3B    | .287<br>.283 | .320                       | .173<br>.169 | .445<br>.425 | .235                  | .255                  | .460                  | .250     | .220<br>.213 | .085     | .100                  | 2,300         | 15-25               |
| 6        | 3/16          | 10-32UNJF-3B   | .307<br>.303 | .340                       | .212<br>.208 | .455<br>.435 | .245                  | .265                  | .470                  | .280     | .251<br>.244 | .085     | .100                  | 2,750         | 25-35               |
| 8        | 1/4           | 1/4-28UNJF-3B  | .412<br>.408 | .440                       | .276<br>.272 | .525<br>.505 | .270                  | .285                  | .540                  | .350     | .314<br>.302 | .090     | .105                  | 5,000         | 60-80               |
| 10       | 5/16          | 5/16-24UNJF-3B | .518<br>.512 | .550                       | .340<br>.334 | .633<br>.613 | .323                  | .338                  | .650                  | .420     | .377<br>.365 | .095     | .110                  | 8,300         | 130-160             |
| 12       | 3/8           | 3/8-24UNJF-3B  | .628<br>.622 | .660                       | .403<br>.397 | .703<br>.683 | .363                  | .378                  | .720                  | .490     | .439<br>.425 | .095     | .100                  | 12,700        | 200-240             |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |
|          |               |                |              |                            |              |              |                       |                       |                       |          |              |          |                       |               |                     |

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.  
 2. Dimensions apply after finish.  
 ③ Burrs from cutoff process and cutting torque-off groove allowed.

MATERIAL: Collar - A-286 high temperature alloy per AMS5731.  
 Washer - 300 series stainless steel.

⊙ FINISH: Collar - HST1397DU() = Solid film lube per AS5272 plus orange identification on body of collar.  
 HST1397PB() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1397TF() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
 Collar & Washer - HST1397TFW() = Collar with Hi-Kote 2 solid film lube. Washer with passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lite Product Specification No. 381.

CODE: Dash number indicates nominal thread size in 1/32nds.  
 See Finish note for explanation of code letters.

⊙ EXAMPLE: HST1397PB8 = 1/4-28 Hi-Lite ST collar with Type II cadmium plate.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.  
 Other U.S. and international patents pending.  
 "Hi-Lite" and "HST" are registered trademarks and  
 "Hi-Lite ST" is a trademark of Hi-Shear Corporation

|            |         |             | TITLE   | DRAWING NUMBER |
|------------|---------|-------------|---|----------------|
| DRAWN      | DATE    | BY          | HI-LITE® ST™ COLLAR                                 | HST1397        |
| APPROVED   | 9-19-85 | D.P.S.      | A-286 HIGH TEMPERATURE ALLOY                        |                |
|            | 9-30-85 | J.RAUSCH    | 1/16" GRIP VARIATION                                |                |
| ① REVISION | 1-18-99 | J.Henderson | SHEAR APPLICATION                                   |                |
|            |         |             | FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE PINS |                |